

Date: Monday, 9/10/2007 1:31:20 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS	
Job Number : 34511		
Estimate Number : 10651		
P.O. Number : <i>N/A</i>	Part Number : D2748	
This Issue : 9/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2748 REV A	<i>50</i>
Prsht Rev. : NC	Project Number : N/A	
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : A	<i>40</i>
Previous Run : 27560	Material : <i>N/A</i>	
Written By : <i>[Signature]</i>	Due Date : 10/10/2007	Qty: <i>20</i> Um: Each
Checked & Approved By : <i>[Signature]</i>		
Comment : Est. B 99.10.27 Now laser cutting EC		
Est Rev:C Now on Waterjet 06-06-16 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0152 sf(s)/Unit Total : 0.3045 sf(s)

304/316 .063 Sheet

Batch: *M101873 HB 07-09-17*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2748

Dwg Rev: *A HB 07-09-17*Prog Rev: *A*

2-Deburr if necessary

*SAB 07/09/20**counted 50*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*HB 07-09-17*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*ES 07/09/20 (50) counted*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges after tumbling

Bend as per Dwg D2748 using bending jig DT 8289

*[Signature] 07/10/07 (50) SAB*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 01/11/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:31:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 34511

Part Number: D2748

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counters*  
*07/11/08* *450*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 46*

*MS 07/11/08* *CU*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*50*  
*07/11/10*

Job Completion



*U 07/11/12*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

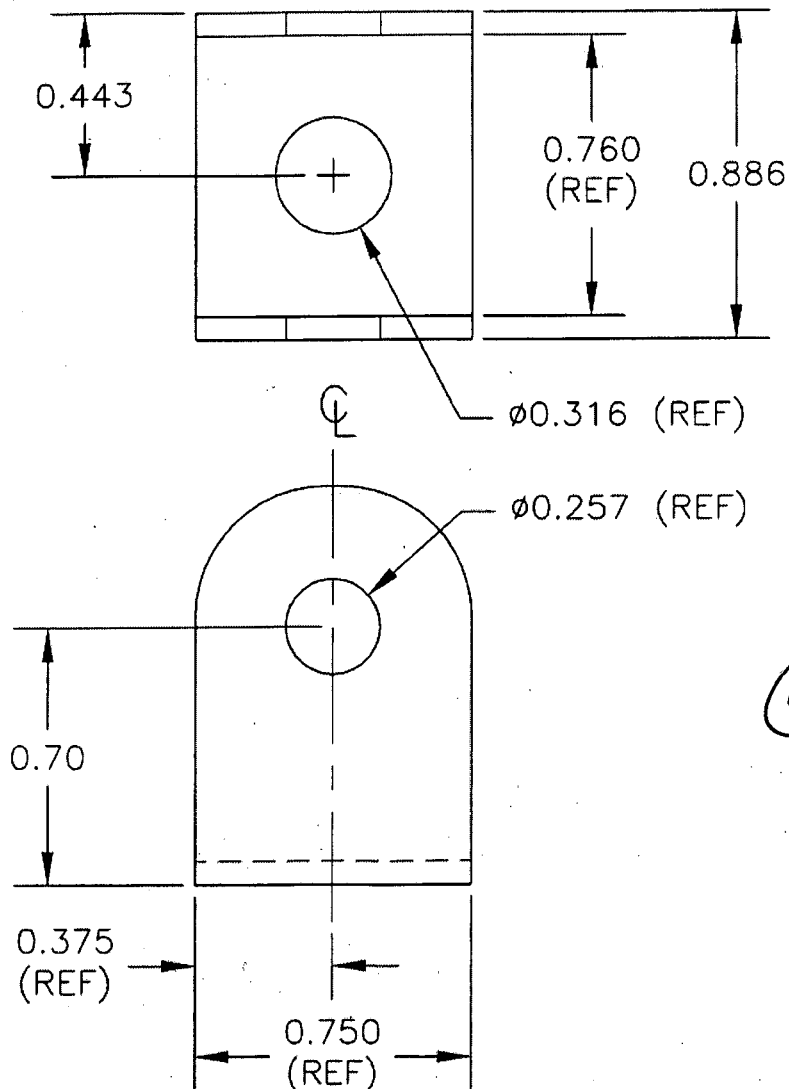
**NOTE:** Date & initial all entries





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2748	REV. A SHEET 1 OF 2
DATE 99.09.24	TITLE CLEVIS		SCALE 2:1
A	99.09.24	NEW ISSUE	

RELEASED  
99.10.12 *KE*



MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.125 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

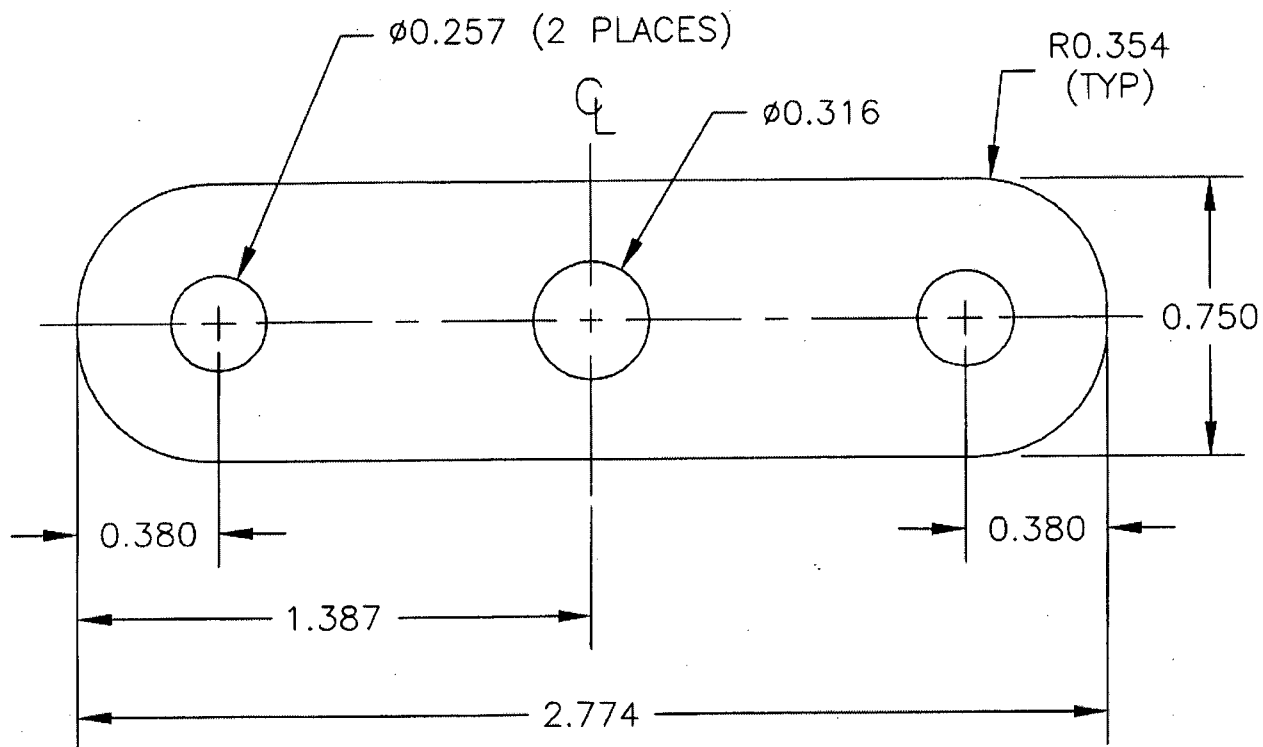
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34511



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2748	REV. A SHEET 2 OF 2
DATE 99.09.24		TITLE CLEVIS	SCALE 2:1

RELEASED  
99.10.12 KE



D2748 FLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34511

MATERIAL: AISI 304/316 SS 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES